

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 27590C		
Estimate Number	: 10382		
P.O. Number	: <i>N/A</i>	Part Number	: D30655
This Issue	: 6/15/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3065 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/15/2006 Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 26928C	Material	: <i>N/A</i>
Written By	: <u><i>[Signature]</i></u>	Due Date	: 7/2/2006
Checked & Approved By	: <u><i>[Signature]</i></u>	Qty:	120 Um: Each
Comment	: Est:C 02.14.01 Incorporated D3066-1 IPP KJ/RF		
	: Est Rev:D Now on Water Jet 06-04-11 JLM		
	: Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM		

Job Number:



Seq. #:	Machine Or Operation:	Description :
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100	1000	1000

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.1338 sf(s)/Unit Total : 136.0548 sf(s)

Material: 6061-T6 0.080" thick
(M6061T6S.080)

Batch:

FLOW WATER JET

2.0 WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: A2

Prog Rev: AZ

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27590C		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-16	2	111 parts Scrap, because the holes were not in tolerance 80.128" & were .140	<i>[Signature]</i>	Scrap & destroy & replace	SAD 06-09-14	<i>[Signature]</i> 06-09-05	<i>[Signature]</i> 06-08-16	<i>[Signature]</i> 06-08-16

Part No: D3065-5 PAR #: N/A Fault Category: Prod / FAB' ISS ^{meo & small} NCR: Yes No DQA: [Signature] Date: 06/10/02

NOTE: Date & initial all entries QA: N/C Closed: [Signature] Date: 06.10.03

Date: Thursday, 6/15/2006 1:56:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27590C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/22 (27)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 06/09/24 126

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 06/09/28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA

TOOR

50

11/19/29 (75)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21


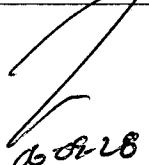
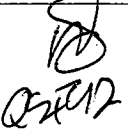

PD 06/09/29

Job Completion



W D 06/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.09.28	7	Lost one piece in Alodine, can't find.		Qty 126.	SAD 06.09.28	 06.09.28	 06.09.28	 06.09.28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

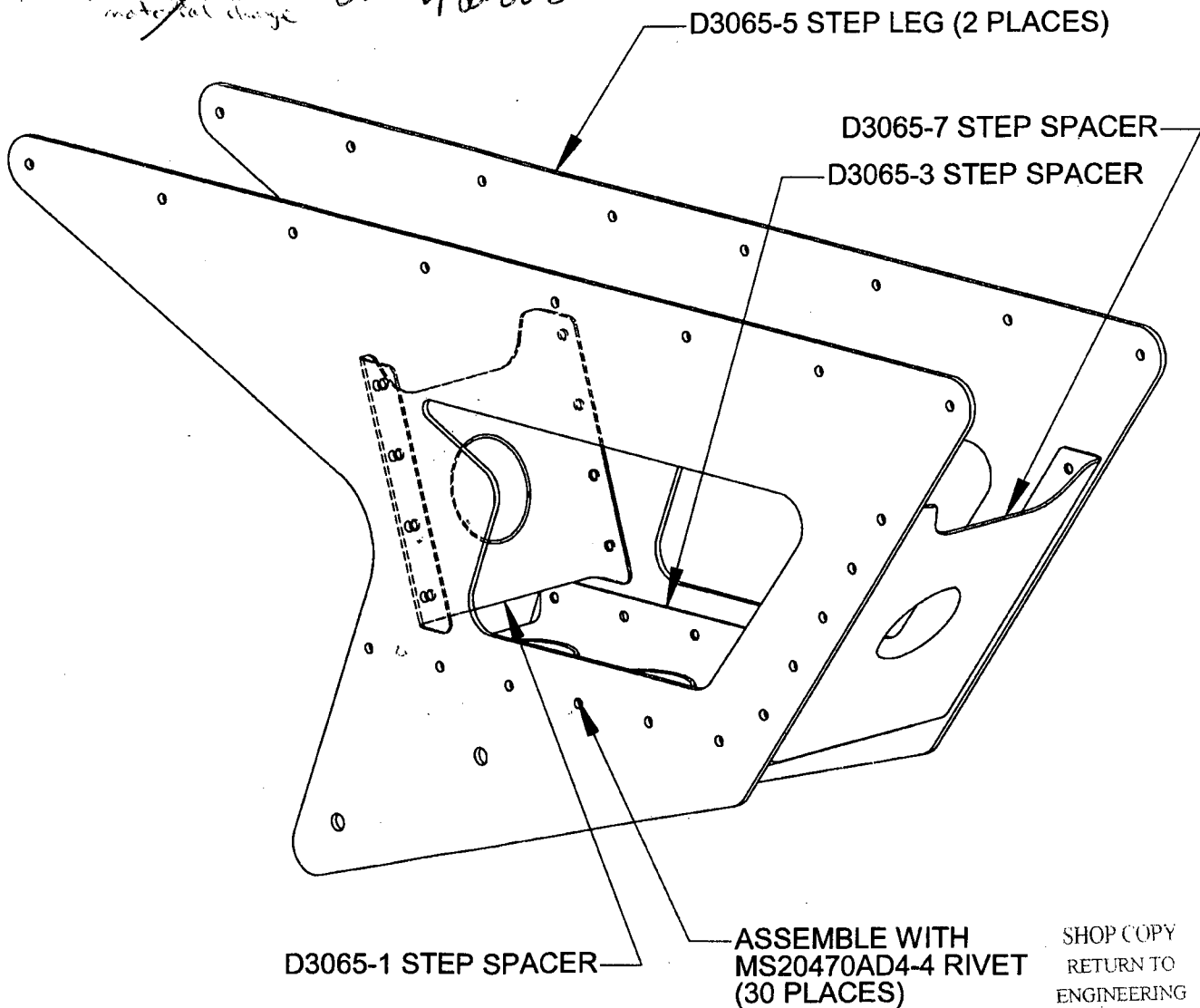
DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE	02.09.11			TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11			NEW ISSUE	
A1	03.02.13 <i>CP</i>			ADD SLOTS TO D3065-5	
A2	03.02.27 <i>CP</i>			0.531 WAS 0.410	

~~RELEASED~~
02.04.20 *#*

UNDER REVIEW

~~02.06 02.06~~
material change

OK *CP* 06.06.13



D3065-041 STEP LEG ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. **27590 C**

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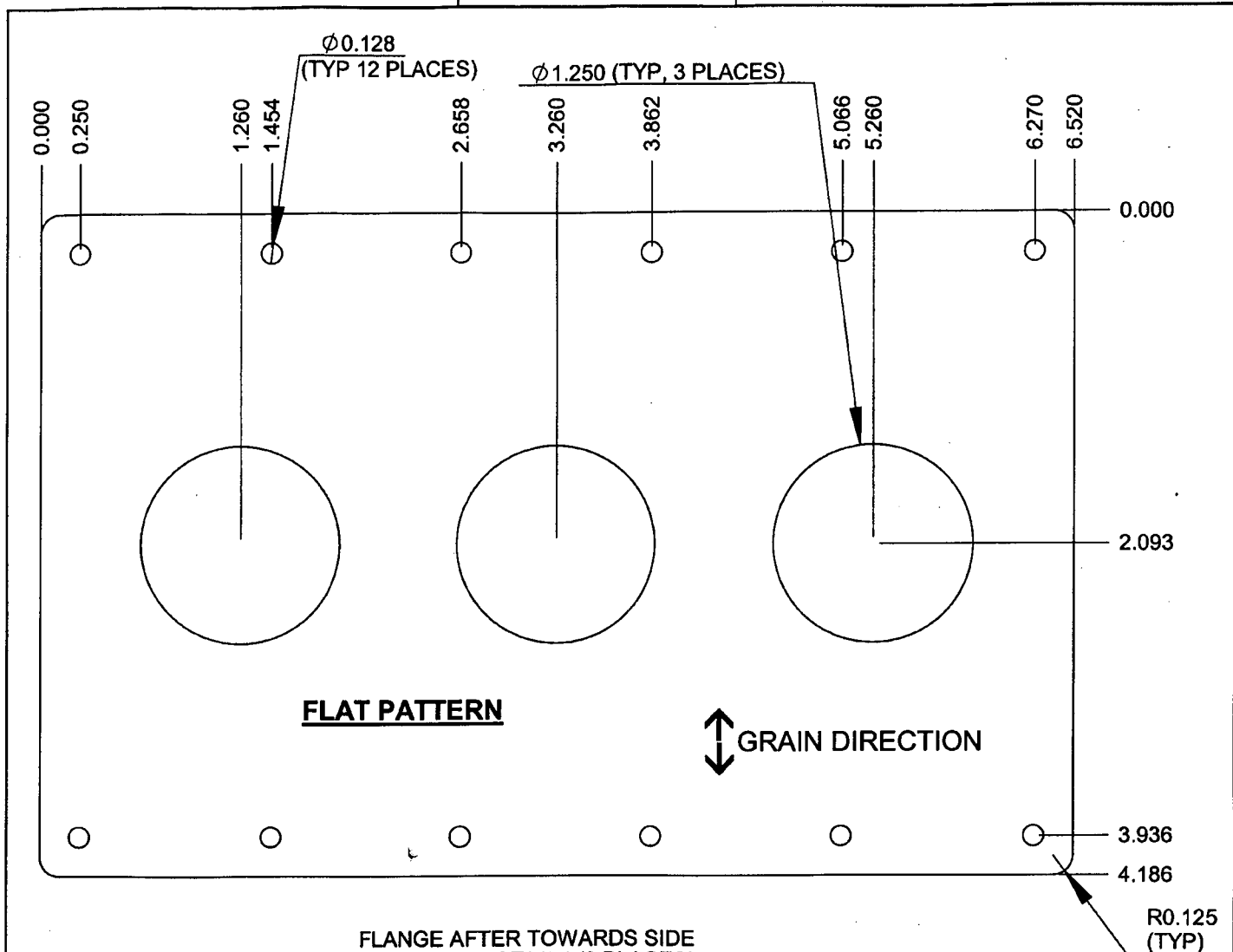
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RELEASED
02.09.20

DART



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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3065	REV. A SHEET 3 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1



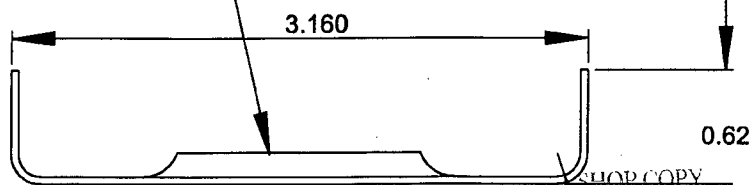
FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

UNDER REVIEW

06.06.02 CB

material change

OK
06.06.15



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. *27590C*

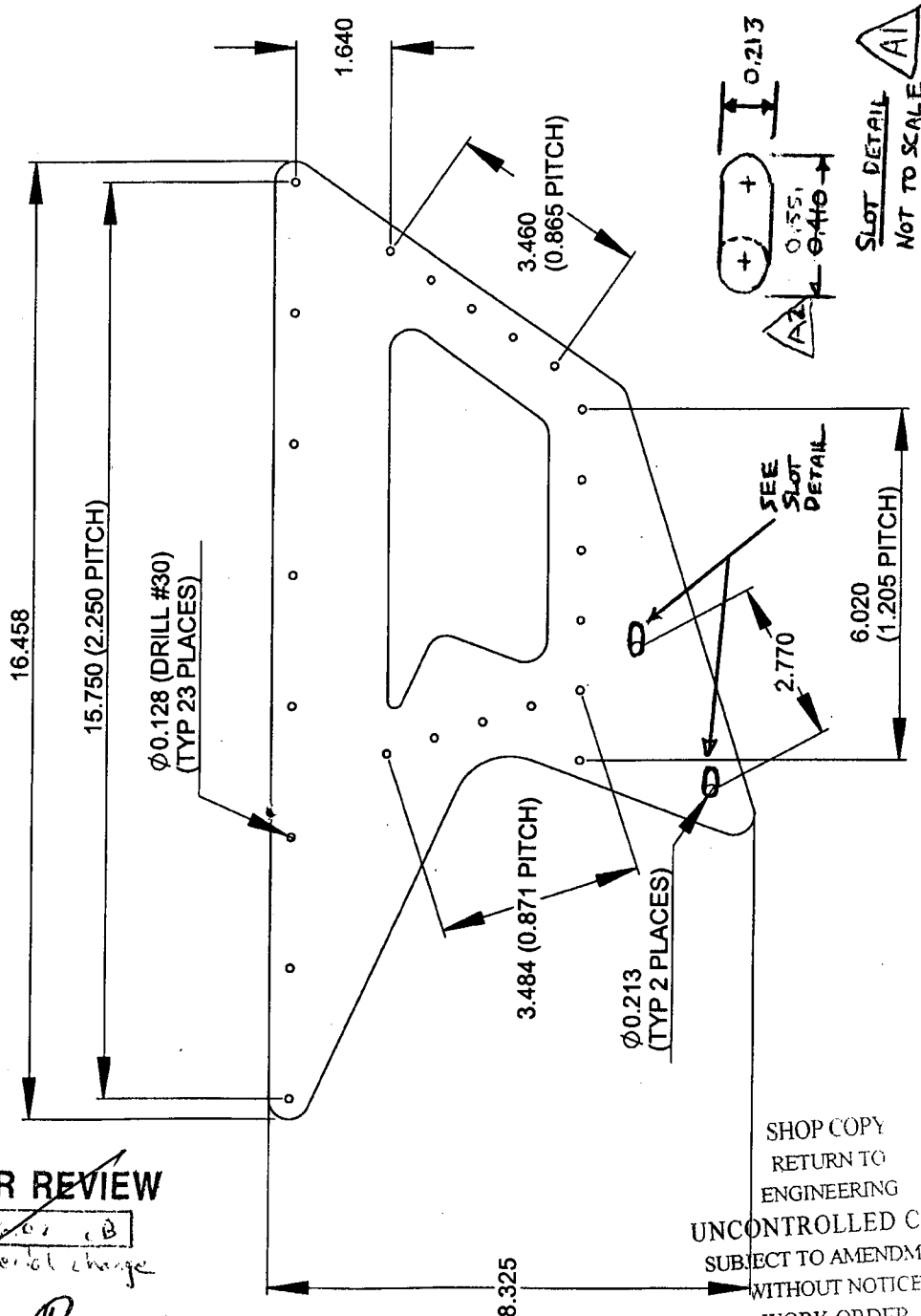
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RECORDED
02.09.20 #



UNDER REVIEW

~~α. 66.07 (B)~~

material change

OK

Pos. 06.15

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WORK ORDER
NO. 27590C

D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

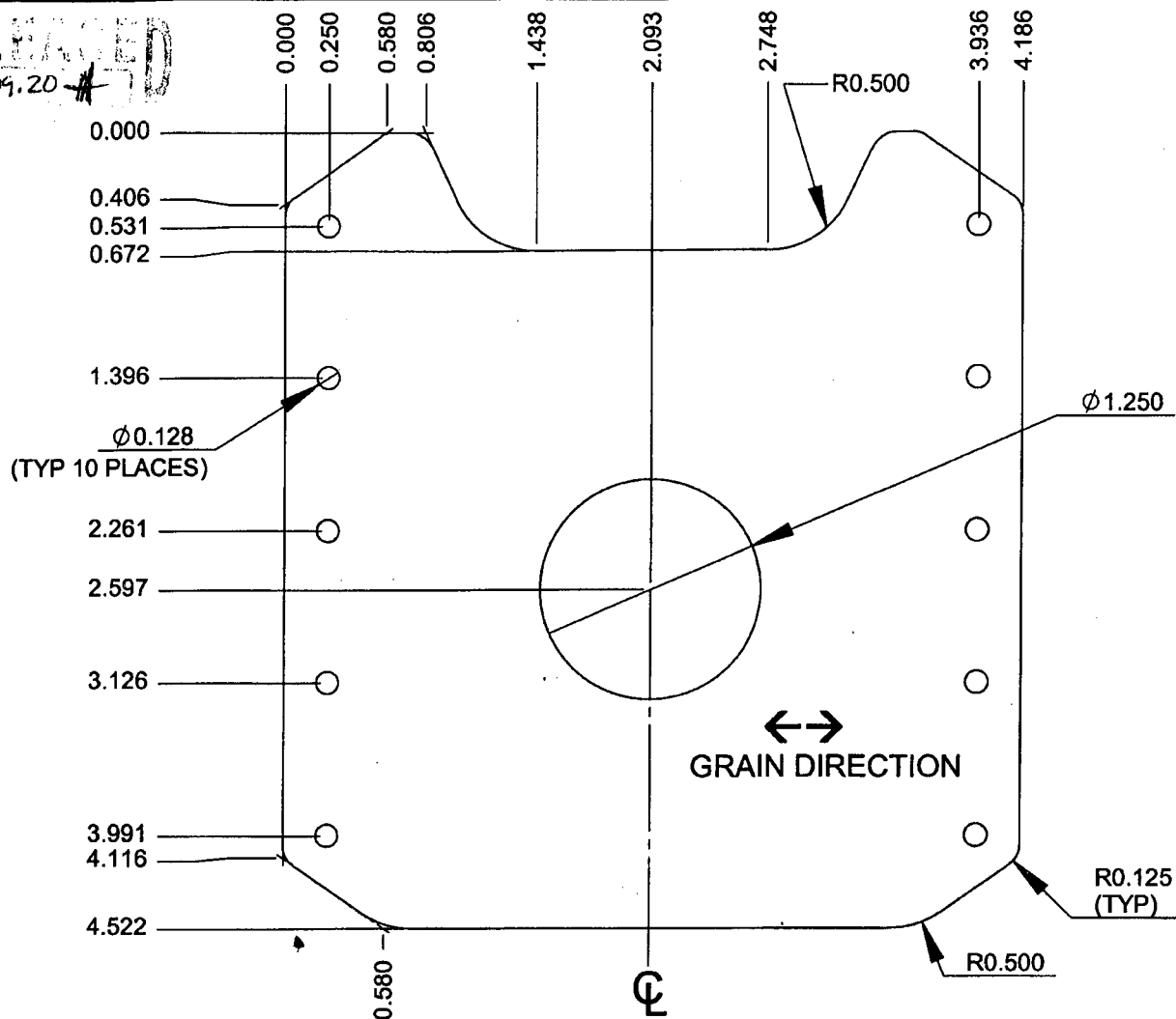
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 5 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20

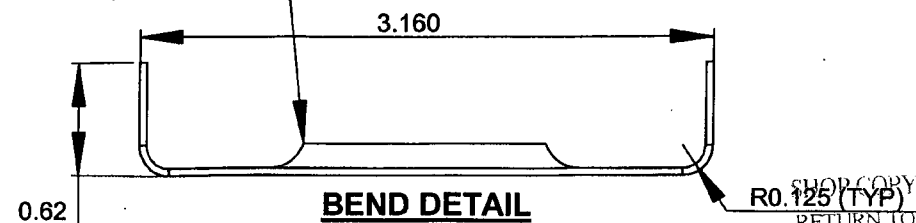


FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

UNDER REVIEW

06.06.05 (13)
material change

OK *CP* 06.06.05



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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~~Scrub~~
Rec'd for Oct 9

06 07 06


Revised by	Approved
KJ/JLM	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by:	<i>MM: MM</i>
Date:	<i>08.08.29</i>

Audited by:	
Date:	16.09.05

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	